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International application number: PCT/US05/013866

International filing date: 20 April 2005 (20.04.2005)

Document type: Certified copy of priority document

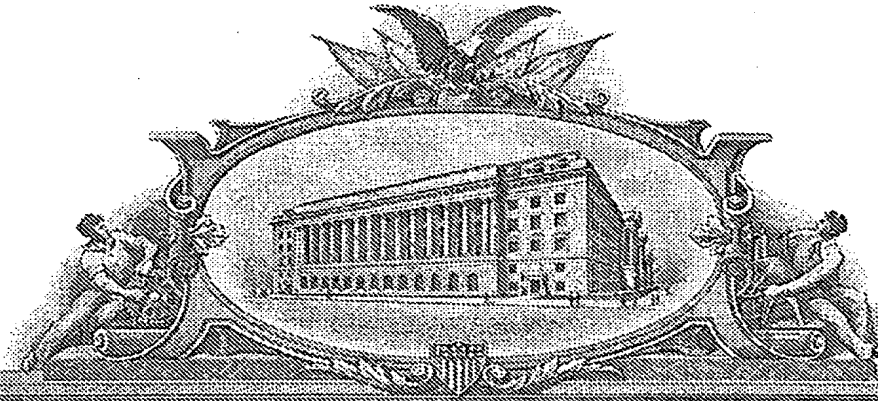
Document details: Country/Office: US
Number: 60/564,039
Filing date: 21 April 2004 (21.04.2004)

Date of receipt at the International Bureau: 30 May 2005 (30.05.2005)

Remark: Priority document submitted or transmitted to the International Bureau in compliance with Rule 17.1(a) or (b)



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APPLICATION NUMBER: 60/564,039

FILING DATE: April 21, 2004

RELATED PCT APPLICATION NUMBER: PCT/US05/13866



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PROVISIONAL APPLICATION FOR PATENT COVER SHEET

This is a request for filing a PROVISIONAL APPLICATION FOR PATENT under 37 CFR 1.53(c).

Express Mail Label No. **EV417440387US**

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Additional inventors are being named on the <u> p. 2 </u> separately numbered sheets attached hereto				
TITLE OF THE INVENTION (500 characters max) ENCAPSULATION OF OILS BY COACERVATION				
Direct all correspondence to: CORRESPONDENCE ADDRESS				
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ENCLOSED APPLICATION PARTS (check all that apply)				
<input checked="" type="checkbox"/> Specification Number of Pages <u> 14 </u>				
<input type="checkbox"/> CD(s), Number _____				
<input checked="" type="checkbox"/> Drawing(s) Number of Sheets <u> 8 </u>				
<input type="checkbox"/> Other (specify) 				
<input type="checkbox"/> Application Date Sheet. See 37 CFR 1.76				
METHOD OF PAYMENT OF FILING FEES FOR THIS PROVISIONAL APPLICATION FOR PATENT				
<input type="checkbox"/> Applicant claims small entity status. See 37 CFR 1.27.				
<input type="checkbox"/> A check or money order is enclosed to cover the filing fees.				
<input checked="" type="checkbox"/> The Director is hereby authorized to charge filing fees or credit any overpayment to Deposit Account Number: <u> 04-1928 </u>				
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FILING FEE Amount (\$) <div style="border: 1px solid black; padding: 10px; width: 150px; margin: 0 auto;">\$160.00</div>				<div style="writing-mode: vertical-rl; transform: rotate(180deg);"> 15535 U.S. PTO 60/564039 </div>
The invention was made by an agency of the United States Government or under a contract with an agency of the United States Government.				
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Respectfully submitted

[Page 1 of 2]

SIGNATURE

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(if appropriate)

(If appropriate)
Docket Number: CL2557 US PRV

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[Page 2 of 2]

Number 2 of 2

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Effective 10/01/2003. Patent fees are subject to annual revision.

☐ Applicant claims small entity status. See 37 CFR 1.27TOTAL AMOUNT OF PAYMENT (\$)**160.00****Complete if Known**

Application Number	To Be Assigned
Filing Date	April 21, 2004
First Named Inventor	Simon Owen Lumsdon Et. Al.
Examiner Name	
Art Unit	
Attorney Docket No.	CL2557USPRV

METHOD OF PAYMENT (check all that apply)☐ Check ☐ Credit card ☐ Money Order ☐ Other ☐ None☒ Deposit Account:

Deposit Account Number: **04-1928**
Deposit Account Name: **E. I. du Pont de Nemours and Company**

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☒ Charge fee(s) indicated below ☒ Credit any overpayments☒ Charge any additional fee(s) or any underpayment of fee(s)☐ Charge fee(s) indicated below, except for the filing fee to the above-identified deposit account.**FEE CALCULATION****1. BASIC FILING FEE**

Large Entity Fee Code (\$)	Small Entity Fee Code (\$)	Fee Description	Fee Paid
1001 770	2001 385	Utility filing fee	
1002 340	2002 170	Design filing fee	
1003 530	2003 265	Plant filing fee	
1004 770	2004 385	Reissue filing fee	
1005 160	2005 80	Provisional filing fee	160.00
SUBTOTAL (1)			(\$)160.00

2. EXTRA CLAIM FEES FOR UTILITY AND REISSUE

Total Claims - 20** = X =
Independent Claims - 3** = X =
Multiple Dependent ☐ YES **290.00** =

Large Entity Fee Code (\$)	Small Entity Fee Code (\$)	Fee Description
1202 18	2202 9	Claims in excess of 20
1201 86	2201 43	Independent claims in excess of 3
1203 290	2203 145	Multiple dependent claim, if not paid
1204 86	2204 43	** Reissue independent claims over original patent
1205 18	2205 9	** Reissue claims in excess of 20 and over original patent

SUBTOTAL (2) (\$)**0.00**

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FEE CALCULATION (continued)**3. ADDITIONAL FEES**

Large Entity Small Entity

Fee Code (\$)	Fee Code (\$)	Fee Description	Fee Paid
1051 130	2051 65	Surcharge - late filing fee or oath	
1052 50	2052 25	Surcharge - late provisional filing fee or cover sheet	
1053 130	1053 130	Non-English specification	
1812 2,520	1812 2,520	For filing a request for <i>ex parte</i> reexamination	
1804 920*	1804 920*	Requesting publication of SIR prior to Examiner action	
1805 1,840*	1805 1,840*	Requesting publication of SIR after Examiner action	
1251 110	2251 55	Extension for reply within first month	
1252 420	2252 210	Extension for reply within second month	
1253 950	2253 475	Extension for reply within third month	
1254 1,480	2254 740	Extension for reply within fourth month	
1255 2,010	2255 1,005	Extension for reply within fifth month	
1401 330	2401 165	Notice of Appeal	
1402 330	2402 165	Filing a brief in support of an appeal	
1403 290	2403 145	Request for oral hearing	
1451 1,510	1451 1,510	Petition to institute a public use proceeding	
1452 110	2452 55	Petition to revive - unavoidable	
1453 1,330	2453 665	Petition to revive - unintentional	
1501 1,330	2501 665	Utility issue fee (or reissue)	
1502 480	2502 240	Design issue fee	
1503 640	2503 320	Plant issue fee	
1460 130	1460 130	Petitions to the Commissioner	
1807 50	1807 50	Processing fee under 37 CFR 1.17(q)	
1808 180	1808 180	Submission of Information Disclosure Stmt	
8021 40	8021 40	Recording each patent assignment per property (times number of properties)	
1809 770	2809 385	Filing a submission after final rejection (37 CFR 1.129(a))	
1810 770	2810 385	For each additional invention to be examined (37 CFR 1.129(b))	
1801 770	2801 385	Request for Continued Examination (RCE)	
1802 900	1802 900	Request for expedited examination of a design application	

Other fee (specify)

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SUBTOTAL (3) (\$)**0.00****SUBMITTED BY**

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Signature	<i>Barbara C. Siegel</i>	Date	4/21/04		

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TITLE
ENCAPSULATION OF OILS BY COACERVATION
FIELD OF THE INVENTION

5 The present invention is in the field of microencapsulation of oils by coacervation.

BACKGROUND OF THE INVENTION

Coacervation offers a wide application range for encapsulation of many types of active ingredients. These active ingredients can include, for example, PUFA (polyunsaturated fatty acid) oils, other food ingredients
10 (flavor oils, vitamins and other hydrophobic components), agrochemical active ingredients and ingredients for health care products. A good understanding of the barrier properties of the coacervate shell and control over the thermal and mechanical stability of the shell can provide, among other things, a variety of specialized applications for this technology,
15 including controlled release, taste masking and the ability to prevent chemical deterioration of the encapsulated oil. Many oils in the food and flavor categories have properties such as strong flavor and instability to oxidation, and thus it is often necessary to encapsulate these oils in a core-shell material to make them palatable and to provide reduced
20 oxidative degradation. One technique that can be used to accomplish this is complex coacervation, [B. K. Green; L. Schleicher, U.S. Patent, 2 800 457, 1957]. This is an established technique that has been used previously in a number of commercial applications [T. G. Lunt, Leatherhead Food RA Research Reports, No. 181, 1972 and R. D. Harding, Leatherhead Food
25 RA Research Reports, No. 194, 1973]. The current invention provides an improved process, as well as products, for the microencapsulation of oils by coacervation as well as a characterization technique to quantify the coating performance.

SUMMARY OF THE INVENTION

30 The present invention describes a process for microencapsulating water insoluble oils, comprising the steps of:

- (a) forming a fine emulsion comprising said water insoluble oil and a complex polysaccharide in the presence of a starch;
- (b) adding to the emulsion of step (a) a protein at a temperature
35 of about 40 C to about 50 C;
- (c) adjusting the pH of the composition of step (b) to a pH below the isoelectric point of said protein;

- (d) densifying the composition of step (c) by cooling said composition to a temperature below 40 C; and
- (e) adjusting the pH of the composition of step (d) to below about pH 10.

5 The invention further describes a process comprising the additional, optional, steps of

- (f) adding a crosslinking agent to the composition of step (e);
- (g) concentrating the microencapsulated composition; and
- (h) spray drying the composition of step (g) to produce dry, microencapsulated oil particles.

10

The invention further relates to products made by the processes described, as well as the compositions of those products.

BRIEF DESCRIPTION OF THE FIGURES

15 Figure 1 is a graph showing the effect of pH on the normalized surface charge of particles of the invention.

Figure 2(a) is an optical micrograph of a coacervate with a mean diameter of 14.6 μm .

Figure 2(b) is a graph showing the particle size distribution of the coacervate particles of Figure 2(a).

20 Figure 3 is an optical micrograph of the coacervate particles that have been spray dried with gelatin.

Figure 4 is a graph showing the effect of temperature in a VLE (vapour-liquid-equilibria) cell on the pressure drop as a function of time.

25 Figure 5 is a graph showing the pressure drop as a function of propanal concentration.

Figure 6 is a graph showing the concentration of oxygen consumed per surface area of coacervate droplets as a function of time.

Figure 7 is a graph showing microcompression data for spray dried coacervate particles of specific diameters.

30 Figure 8 is a photograph of a VLE cell.

DETAILS OF THE INVENTION

35 The coacervation process generally involves the formation of an oil-in-water emulsion, which is stabilized by a polysaccharide and a soluble protein. These molecules are interwoven through electrostatic interactions to form a core-shell material around the dispersed oil droplets. In previous work, the initial oil-in-water emulsion was stabilized by the soluble protein (e.g. gelatin) [W. M. McKernan, Flavour Industry, v.4, (2), 70-74, 1973]. Addition of a polysaccharide (e.g. gum arabic) to the dispersion, followed

by lowering the pH below the iso-electric point of the protein, initiated the strong electrostatic interaction between the molecules. The resultant shell was hardened by cooling and further stabilized by addition of a cross-linking agent (e.g. glutaraldehyde).

5 However, the application of this classical coacervation method to oil encapsulation was unsatisfactory due to poor emulsion stability in the presence of gelatin. The oil-in-water emulsion, formed, for example, by using a rotor-stator homogenizer at 40 °C, was found to be more stable in the presence of the polysaccharide (gum arabic) than the soluble protein
10 (gelatin), and was further stabilized by the addition of a waxy corn starch (high amylopectin content). Starch is commonly used as a stabilizing agent and also contributes to the oxygen barrier properties of the coating. [R. Buffo, G. Reineccius, *Perfumer & Flavorist*, 25 (3), 37-51, 2000]. The coacervation proceeds by adding the gelatin solution to the emulsion at 40
15 °C. The natural pH of the dispersion containing gelatin, gum arabic, starch and PUFA oil is approximately 5.5. When the pH was lowered to 4 using 1.0 M citric acid, the charge on the gelatin molecule changed from negative to positive, which initiated an interaction with the negatively charged gum arabic, as shown in Figure 1.

20 The resultant shell can be hardened by cooling to 5 °C for 45 minutes, and can be stabilized further by addition of glutaraldehyde at pH 9 (following 1.0 M NaOH addition), which binds to the amino sites on the gelatin molecule in a cross-linking reaction. The resultant coacervate contained spherical droplets of diameter between 2 and 40 µm (depending
25 on the speed of the rotor-stator and the concentration of ingredients), which did not coalesce within the time-frame studied (at least 3 months) as shown in Figure 2.

 Literature suggests that coacervate capsules have a continuous shell, although the shell is not of uniform thickness [P. Vilstrup, ed.
30 'Microencapsulation of Food Ingredients', Leatherhead, Surrey, 2001]. Paetznick [D. J. Paetznick, G. A. Reineccius, T. L. Peppard, in *Controlled Release Society 30th Annual General Meeting*, Glasgow, Scotland, 2003] reports that most coacervates that are commercially available show a Rugby-ball shaped morphology. This particular morphology does not use
35 the coating material efficiently since parts of the active material are only protected by a thin layer whereas larger amounts of encapsulate material is concentrated at the tips of the Rugby-ball shaped particle. The coacervates of the present invention show a spherical shape, providing a

better utilization of the encapsulate material. The mixing and dispersion conditions during the coacervation process are believed to influence the final encapsulate shape. See Figure 2.

5 If desired, the final coacervate can be spray dried to remove excess water, resulting in particles of diameter between about 25 and 100 μm (Figure 3).

10 In the present invention, the integrity of the core-shell material was characterized further using surface oil measurements. In this experiment the coacervate was agitated thoroughly with hexane, in order to solubilize any un-encapsulated or poorly encapsulated PUFA oil. The hexane is then separated and evaporated to dryness so that any residual PUFA oil could be detected. In the majority of cases, less than 1% of the total oil in the coacervate was found to be surface oil. Thus, the microencapsulation process is found to be very efficient.

15 One primary purpose of the core-shell material is to protect the PUFA oil droplets from oxidation. Oxidation leads to the formation of various degradation products many of which have off tastes and odours, including propanal. A test of this aspect can be carried out in a VLE cell, as shown in C.-P. Chai Kao, M. E. Paulaitis, A. Yokozeki, *Fluid Phase*
20 *Equilibria*, 127, 191 (1997), which enables work at elevated temperature and pressure under continuous stirring. The consumption of oxygen can be measured by recording the pressure drop as a function of time (Figure 4), which we have shown to be in direct correlation with propanal production via GC analysis of the aqueous phase throughout the
25 experiment (Figure 5). Applicants have noted that an uncoated sodium dodecyl sulphate (SDS)-stabilized PUFA emulsion degrades completely in just over 6 hours at 60 °C (Figure 4). In contrast, a coacervate at the same temperature begins to degrade after 2 days. For an identical coacervate formulation, the rate of degradation is almost doubled by
30 increasing the temperature by 10 °C to 70 °C, and again to 80 °C. Even at 80 °C however, the coacervate is more stable than the SDS emulsion at 60 °C.

In Figure 5 the pressure drop is plotted as a function of the propanal concentration for the SDS stabilized PUFA emulsion. The linear correlation
35 confirms that PUFA degradation is directly proportional to oxygen consumption.

The flux of molecules across the coating layer can be determined by plotting the moles of oxygen consumed per surface area of the droplets

as a function of time (Figure 6). The surface area was calculated from the particle size distributions measured on the Malvern Mastersizer 2000, with Hydro 2000S presentation unit. The slope of these lines gives a direct indication of the quality of the coating.

- 5 Coacervates with a low concentration of formulation ingredients (Curve D) show a steep slope suggesting the thickness of the coating is not high enough to prevent oxidation. As the concentration of ingredients increases (Curve A), the slope levels off, confirming that coating thickness is a critical factor in oxidation stability. Curve E shows the flux across an
10 SDS surfactant-stabilized emulsion. This provides a minimal barrier to oxidation so there is a high flux in and out of the droplet.

- The integrity of the coating around a single spray dried particle has been tested using a Shimadzu Micro-compression unit (MCTM-500, with 500 μ m tip), which measures the displacement as a function of the load
15 applied to the particle, as shown in Figure 7. At the end of each compression experiment the particle bursts and the fragmented shell can be seen around the free oil.

 As used herein, the term "emulsion" means a stable dispersion of one liquid in a second immiscible liquid.

- 20 As used herein, the term "emulsification" refers to a process of dispersing one liquid in a second immiscible liquid. Generally, shear is required for the formation of emulsion droplets, which can be generated from a variety of dispersion devices including but not limited to microfluidizers, high-pressure homogenizers, colloid mills, rotor-stator
25 systems, microporous membranes, ultrasound devices, and impeller blades.

 As used herein, "water solubility" refers to the number of moles of solute per liter of water that can be dissolved at equilibrium temperature and pressure.

- 30 As used herein, "water insoluble oils" are those oils having a solubility of generally less than about 4 weight percent in water. Non-limiting examples of such oils include: marine oils (whale oil, seal oil, fish oil, algae oil); oils of plant origin (fruit pulp oils such as olive and palm oils; seed oils such as sunflower, soy, cottonseed, rapeseed, peanut, and
35 linseed oils); oils of microbial origin; poly-unsaturated fatty acid (PUFA) oils; flavor oils (citrus, berry, flavorings including aldehydes, acetates and the like; (R)-(+)-limonene); pharmaceuticals (including nutraceuticals) and

crop protection chemicals (e.g. insecticides, herbicides and fungicides) whether as liquids or as solutions of the active ingredient in carrier oil.

As used herein, "starch" refers to a complex carbohydrate widely distributed in plant organs as storage carbohydrates. Typical raw materials for starches are corn, waxy corn, potato, cassava, wheat, rice, and waxy rice. Starch is typically a mixture of two glucans (amylose and amylopectin), and its properties can be adjusted by physical and chemical methods to produce modified starches. The starches find use in the present invention when used as an aqueous solution with polysaccharides, to stabilize an oil-in-water emulsion.

As used herein, "polysaccharides" refers to monosaccharides bound to each other by glycosidic linkages. These are used with the starches to stabilize the oil-in-water emulsions. Non-limiting examples of polysaccharides useful in the present invention include: gum arabic, carageenans, xanthan gum, pectin, cellulose, cellulose derivatives, agar, alginates, furcellaran, gum ghatti, gum tragacanth, guaran gum, locust bean gum, tamarind flour, arabinogalactan.

As used herein, "protein" refers to any of numerous naturally occurring complex substances that consist of amino-acid residues joined by peptide bonds, and contain the elements carbon, hydrogen, nitrogen, oxygen, usually sulfur, and occasionally other elements (as phosphorus or iron), and include many essential biological compounds (as enzymes, hormones, or immunoglobulins). In the present invention, they are generally added as an aqueous solution to the oil-in-water emulsion. Non-limiting examples include gelatins, β -lactoglobulin, soy and casein.

As used herein, "microencapsulation" refers to the formation of a shell around a particle of material for the purpose of controlling the diffusion of molecules from, or into, the particle. The shell thickness is not necessarily uniform. In the present invention, the shell may be used to protect the encapsulated oil from oxygen degradation. It may also be used to control the release of flavor or crop protection active ingredient out of the particle. Generally the microencapsulated particles of the present invention are between 1 and 100 μm in diameter, depending on the shear during emulsification. Generally, higher shear provides smaller particles.

As used herein, a "cross-linking agent" is optionally employed. The agent is used to cross-link the protein molecule in the shell material by forming bonds between the carboxyl groups on the aldehyde moiety and the amine groups on the protein moiety. While many different cross-

linking agents could be used, a particularly useful one for the present invention is glutaraldehyde, which is FDA approved for use in specific food applications at low concentrations (see 21 CFR 172.230).

5 Spray drying is optionally employed in the present invention. This involves the atomization of a liquid feedstock into a spray of droplets and contacting the droplets with hot air in a drying chamber. The sprays are generally produced by either rotary (wheel) or nozzle atomizers. Evaporation of moisture from the droplets and formation of dry particles proceeds under controlled temperature and airflow conditions. Many
10 ingredients in the food industry are spray dried such as milk powder, instant coffee, soy protein, gelatin, flavors and vitamins. Other methods of drying include pneumatic conveying drying, vacuum freeze drying.

In the examples below, all chemicals and reagents were used as received from Aldrich Chemical Co., Milwaukee, WI, unless otherwise
15 specified.

"Strawberry jammy" flavor from USA Flavors, Dayton, NJ (flavor compound comprising acetic acid, 003A422).

"Citrus" flavor from USA Flavors, Dayton, NJ (flavor compound comprising D-limonene, methyl acetate and propionaldehyde, 48364).

20 PUFA – RoPUFA '30' n-3 food oil, Roche.

Gelatin – Polypro 5000, Liener-Davis USA.

Gum Arabic – TIC Pretested® Pre-hydrated Gum Arabic Spray Dry FCC Powder, TICGums, Belcamp, MD.

Starch – National Starch & Chemical Co., Bridgewater, NJ.

25 Glutaraldehyde – EM Science, 25% in water, Gibbstown, NJ.

EXAMPLES

Example 1

Micro-encapsulates of mean diameter ranging between 1 and 100 µm, were prepared from formulations containing gelatin, gum arabic, starch
30 and a cross-linking agent.

(A) Preparation of aqueous solutions

A solution in distilled water containing 2-10 wt.% gum arabic and 2-10 wt%
35 starch was prepared by magnetic agitation for 15 minutes at 40 °C. A separate solution of 10-20wt.% gelatin in distilled water was also prepared at 40 °C.

(B) Emulsification

45g of the gum arabic/starch solution was then emulsified with 5g of polyunsaturated fatty acid (PUFA) oil by mechanical agitation for 5 minutes at 6500-13500 rpm (Ultra-Turrax T25 Basic – IKA Werke).

(C) Coacervation

50g of gelatin solution was then added (sub-surface) to the magnetically agitated emulsion and the pH lowered to 4 using 1M citric acid solution. This dispersion was then cooled to 5 °C in a water/ice-bath for 30 minutes with continuous magnetic agitation.

(D) Cross-linking

The sample was removed from the ice-bath and the pH raised to 9 using 1M NaOH solution. 5ml of the cross-linking agent was then added as a 4-8wt.% aqueous solution, with continuous magnetic agitation.

(E) Centrifugation

The micro-encapsulated particles were then concentrated in a centrifuge at 2000 G for 5 minutes, and the concentrated cream was then separated from the resolved aqueous phase, by skimming. The cream had an encapsulated oil content of between 35 and 55 %, with less than 1% un-encapsulated oil.

The oxidation barrier performance of the micro-encapsulates was determined by measuring the consumption of oxygen and evolution of propanal at elevated temperature (70 °C) and pressure (100 psia). The consumption of oxygen was shown to be directly proportional to the evolution of propanal. The flux of oxygen through the encapsulating shell was measured by plotting the mols of oxygen consumed per surface area of the droplets as a function of time, as shown in Figure 6.

Example 2

Micro-encapsulates of mean diameter ranging between 1 and 100 μm , were prepared from formulations containing gelatin, gum arabic, starch and a cross-linking agent.

5

The protocol described in Example 1 was repeated, replacing the poly-unsaturated fatty acid (PUFA) oil with (R)-(+)-limonene, a flavor oil. This gave a creamy yellow dispersion, containing spherical droplets, with no free un-encapsulated oil. The size of the encapsulated droplets remained

10

constant for at least 1 week.

Example 3

Micro-encapsulates of mean diameter ranging between 1 and 100 μm , were prepared from formulations containing gelatin, gum arabic, starch and a cross-linking agent.

15

The protocol described in Example 1 was repeated, replacing the poly-unsaturated fatty acid (PUFA) oil with an agricultural active ingredient for example IN-KN128, (Indoxacarb available commercially) which is an insecticide, dissolved in methylated seed oil. This gave an opaque dispersion, containing spherical droplets, with no un-encapsulated oil. Again, the drop size remained constant for at least 1 week.

20

Example 4

The protocol in Example 1 is repeated to form PUFA oil micro-encapsulates of mean diameter ranging between 1 and 100 μm , prepared from formulations containing β -lactoglobulin (instead of gelatin), gum arabic and starch. No cross-linking agent was used in this formulation. The continuous aqueous phase surrounding the particles was analyzed for propanal after the coacervate had been stored in an oven at 60 $^{\circ}\text{C}$ for 4 days. No propanal was detected. The gelatin coacervate also prevented the detectable evolution of propanal under the same conditions. Propanal is a recognized product of PUFA oil degradation.

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30

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Example 5

The protocol in Example 1 was repeated to form PUFA oil micro-encapsulates of mean diameter ranging between 1 and 100 μm , prepared from formulations containing cellulose (instead of gum arabic), starch and

gelatin. Minimal surface oil was detected (<0.25%) and the droplets were stable for at least 1 week.

Examples 6 and 7

- 5 The protocol in Example 1 was repeated to form flavor oil microencapsulates of mean diameter ranging between 1 and 100 μm , prepared from formulations containing 5 wt. % flavored oil (strawberry jammy or citrus), 8 wt. % gum arabic, 8 wt. % starch and 20 wt. % gelatin. No cross-linking agent was used. The homogenization speed was 9500 rpm (Ultra-Turrax T25 Basic – IKA Werke). The encapsulates were isolated after concentrating by centrifuge at 2000 G (Beckman Coulter Allegra® 21R) and spray dried.

Comparative Example A

- 15 The PUFA oil-in-water emulsion was stabilized using 8mM SDS (Sodium dodecyl sulphate) in water. SDS is an anionic surfactant purchased from (Acros Chemical, NJ). The oil drops are between 1 and 100 μm in diameter, depending on the speed of emulsification. These drops have an equivalent surface area to the coacervate particles but do not provide a barrier to oxidation.
- 20

CLAIMS

What is claimed is:

1. A process for microencapsulating water insoluble oils,
5 comprising the steps of:
 - (a) forming a fine emulsion comprising said water insoluble oil and a complex polysaccharide in the presence of a starch;
 - (b) adding to the emulsion of step (a) a protein;
 - 10 (c) adjusting the pH of the composition of step (b) to a pH below the isoelectric point of said protein;
 - (d) densifying the composition of step (c); and
 - (e) adjusting the pH of the composition of step (d) to below about pH 10.
- 15 2. The process of claim 1, wherein at step (b) the temperature of the emulsion is about 40C to about 50C.
3. The process of any preceding claim wherein at step (d) densification is accomplished by cooling said composition to a
20 temperature below about 40C.
4. The process of any preceding claim, further comprising step (f); adding a cross-linking agent to the composition of step (e).
25 5. The process of any preceding claim, further comprising step (g); concentrating the microencapsulated composition of step (e) or (f).
6. The process of any preceding claim, further comprising step (h); spray drying the composition of step (e), (f) or (g) to produce dry,
30 microencapsulated oil particles.
7. The process of claim 5 or 6, wherein at step (g) the composition is concentrated by centrifugation.
35 8. The process of any preceding claim, wherein the water insoluble oil is selected from the group consisting of a marine oil, a plant

oil, a microbial oil, a poly-unsaturated fatty acid oil (PUFA), a flavor oil, an oil comprising an agriculturally active ingredient and an oil comprising a pharmaceutical.

- 5 9. The process of any preceding claim wherein the polysaccharide is selected from the group consisting of gum Arabic, carageenans, xanthan gum, pectin, cellulose, cellulose derivatives, agar, alginates, furcellan, gum ghatti, gum tragacanth, guaran gum, locust bean gum, tamarind flour and arabinogalactan.
- 10 10. The process of any preceding claim wherein the protein is selected from the group consisting of gelatin, β -lactoglobulin, soy and casein.
- 15 11. The process of any preceding claim wherein the water insoluble oil is a PUFA; wherein the polysaccharide is gum arabic; wherein the protein is gelatin; and wherein the cross-linking agent is glutaraldehyde.
- 20 12. The process of any preceding claim 1 to 10 wherein the water insoluble oil is a PUFA; wherein the polysaccharide cellulose; wherein the protein is gelatin; and wherein the cross-linking agent is glutaraldehyde.
- 25 13. The process of any preceding claim 1 to 3 and 5 to 10 wherein the water insoluble oil is a PUFA; wherein the polysaccharide is gum arabic; wherein the protein is gelatin; and wherein no cross-linking agent is used.
- 30 14. The process of any preceding claim 1 to 10 wherein the water insoluble oil is a flavor oil; wherein the polysaccharide is gum arabic; wherein the protein is gelatin; and wherein the cross-linking agent is glutaraldehyde.
- 35 15. The process of any preceding claim 1 to 10 wherein the water insoluble oil is an agriculturally active ingredient; wherein the

polysaccharide is gum arabic; wherein the protein is gelatin; and wherein the cross-linking agent is glutaraldehyde.

5 16. The process of any preceding claim 1 to 10 wherein the water insoluble oil is a pharmaceutical; wherein the polysaccharide is gum arabic; wherein the protein is gelatin; and wherein the cross-linking agent is glutaraldehyde.

10 17. A product made by the process of any preceding claim.

TITLE

ENCAPSULATION OF OILS BY COACERVATION

ABSTRACT

The present invention describes the encapsulation of water
5 insoluble oils by coacervation and the subsequent reduction in oxidative
degradation of these oils in microencapsulated forms. Water insoluble oils
useful in the process of the invention include food oils such as PUFA,
flavor oils, and agriculturally and pharmaceutically active oils.

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KWG/klb

Figure 1

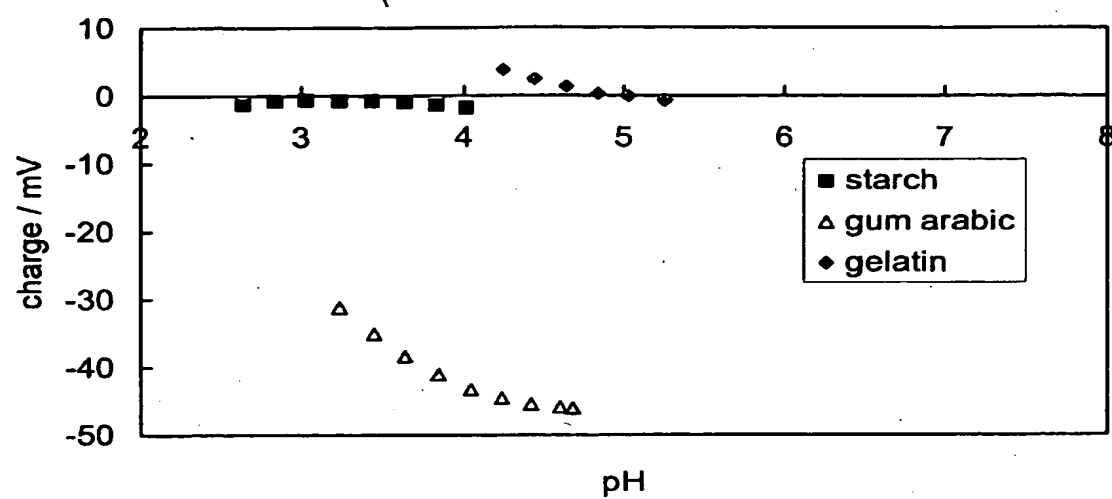


Figure 2

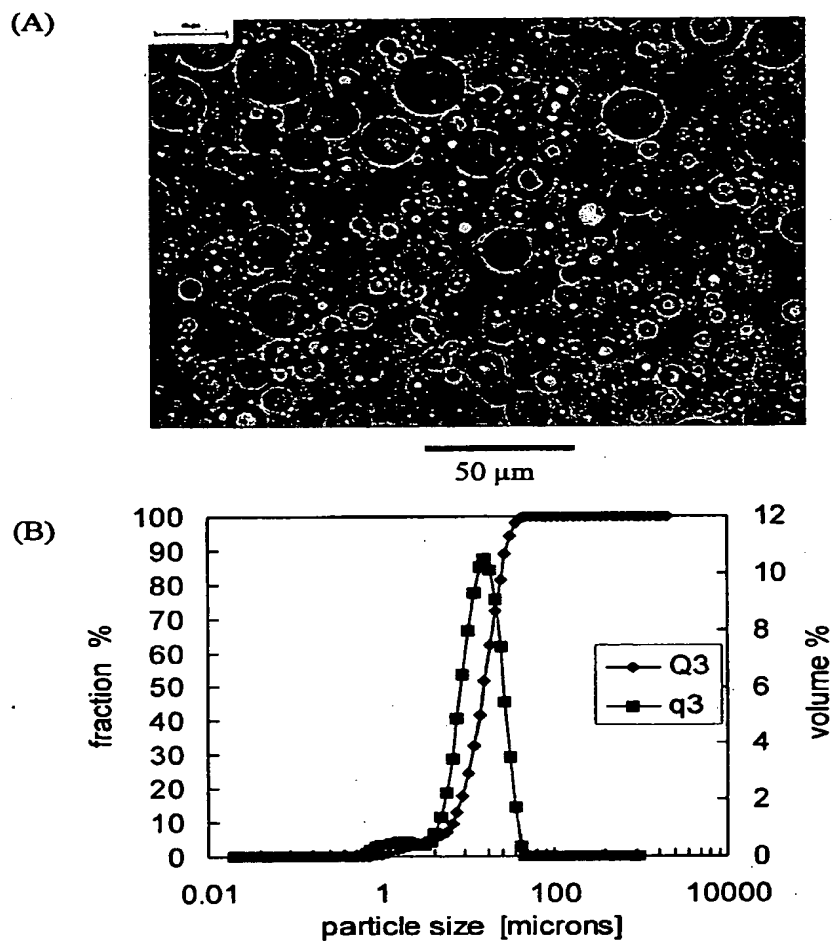
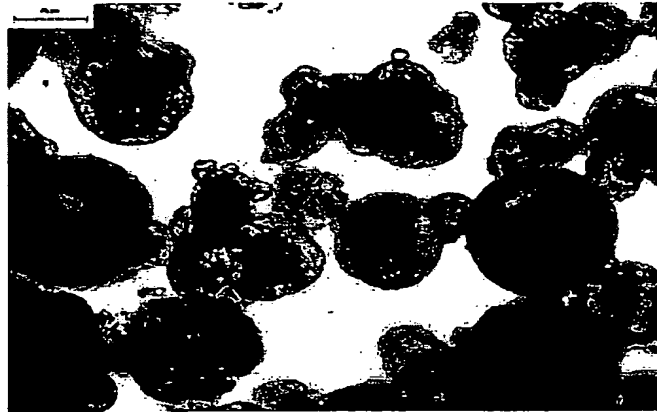


Figure 2 (A) Optical micrograph of a coacervate with a median diameter of 14.6 μm , as measured by light scattering (B).

Figure 3:



50 μm

Figure 4. Effect of temperature in VLE cell on the pressure drop as a function of time for 5 wt.% PUFA oil coacervates and an SDS stabilized emulsion at 60 °C.

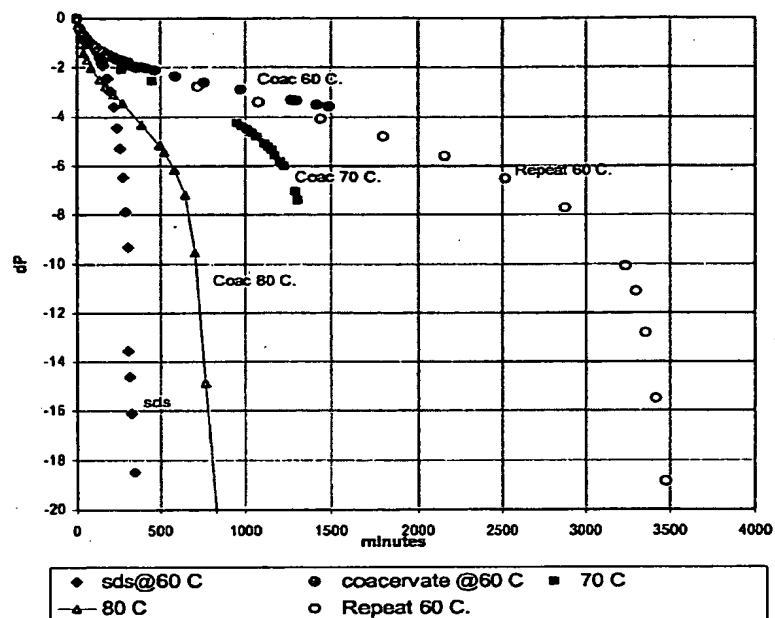


Figure 5

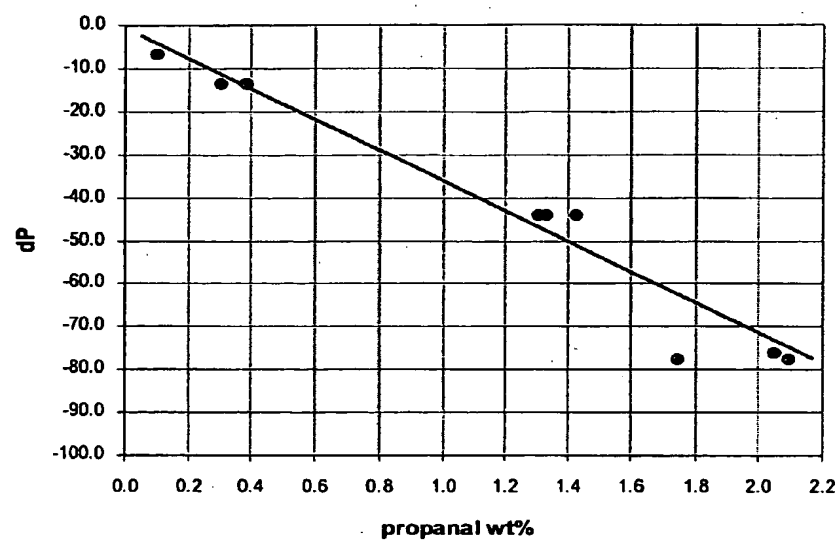
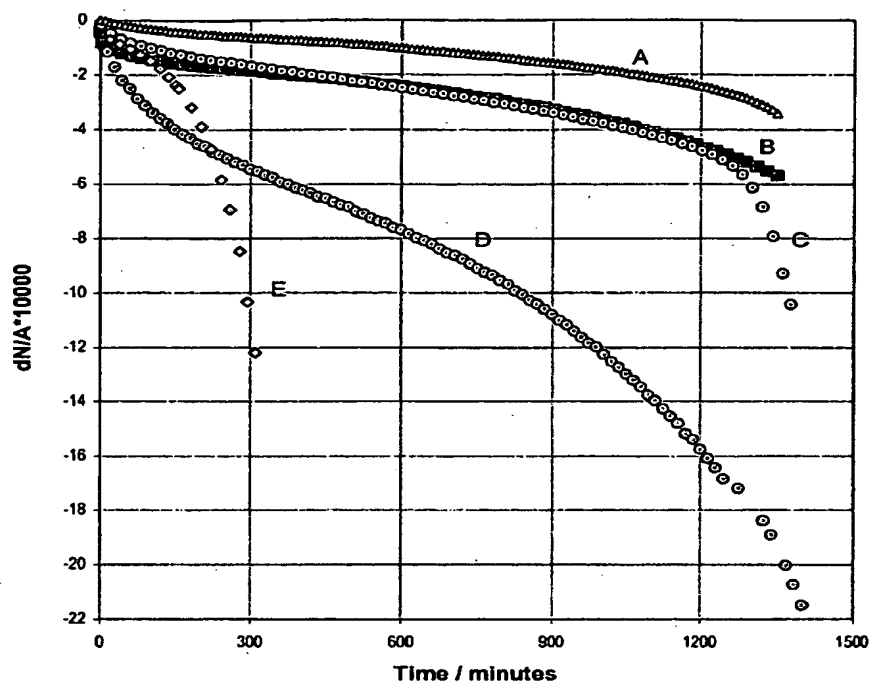


Figure 5. Pressure drop as a function of propanal concentration for an SDS stabilized 5wt.% PUFA emulsion.

Figure 6. Concentration of oxygen consumed per surface area of droplets as a function of time.



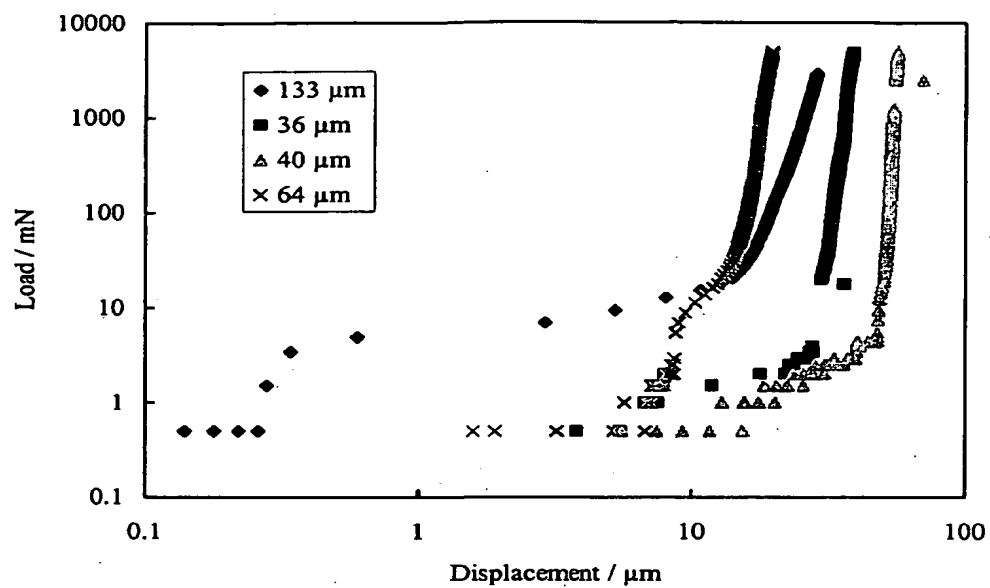
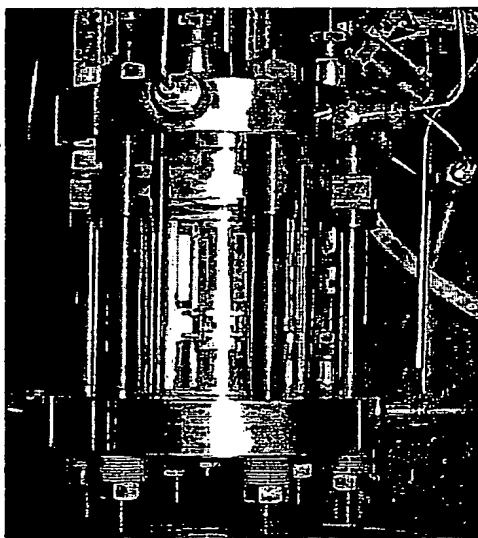


Figure 7: Micro-compression data on spray dried coacervate particles of specified diameter

Figure 8: VLE cell



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International application No. PCT/US2005/013866				International filing date (day/month/year) 20 April 2005 (20.04.2005)	
International publication date (day/month/year)				Priority date (day/month/year) 21 April 2004 (21.04.2004)	
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